

Work Order ID 93501***93501***

Page 1

Friday, November 16, 2012 7:30:53 AM

Item ID: D3646-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Arm

Start Date: 11/16/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/27/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: *MKF*Date: *12-11-16* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3646	C								
100	NC BRAKE	0.00							
100									
Brake NC	Memo	0.00							
Brake NC	I-Punch to length as per Dwg D3646 & template DT8958								
110	Small Fab	0.00							
110									
Small Fab	Memo	0.00							
Small Fab	I-Deburr								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

*(4) SAO 12-11-16**(4) SAO 12-11-16**(4) 12-11-16**DAS
09
2-89*

Work Order ID 93501

Friday, November 16, 2012 7:30:53 AM

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Page 2

Item ID: D3646-2

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Arm

Stop

NS2

Start Date: 11/16/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/27/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

130

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11-50
320 OF
12-20

4X ✓

mt
12/11/19

140

QC3- Inspect Part Finish

0.00

140

QC

Quality Control

Memo

0.00

4 ✓

12/11/19



150

Identify as per dwg & Stock Location: 57227

0.00

150

Packaging

Packaging

Memo

0.00

4

12/11/2020

Work Order ID 93501

Friday, November 16, 2012 7:30:53 AM

93501

Page 3

Item ID: D3646-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Arm

Stop ***NS2***

Start Date: 11/16/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/27/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC21- Final Inspection - Work Order Release

0.00

160

QC

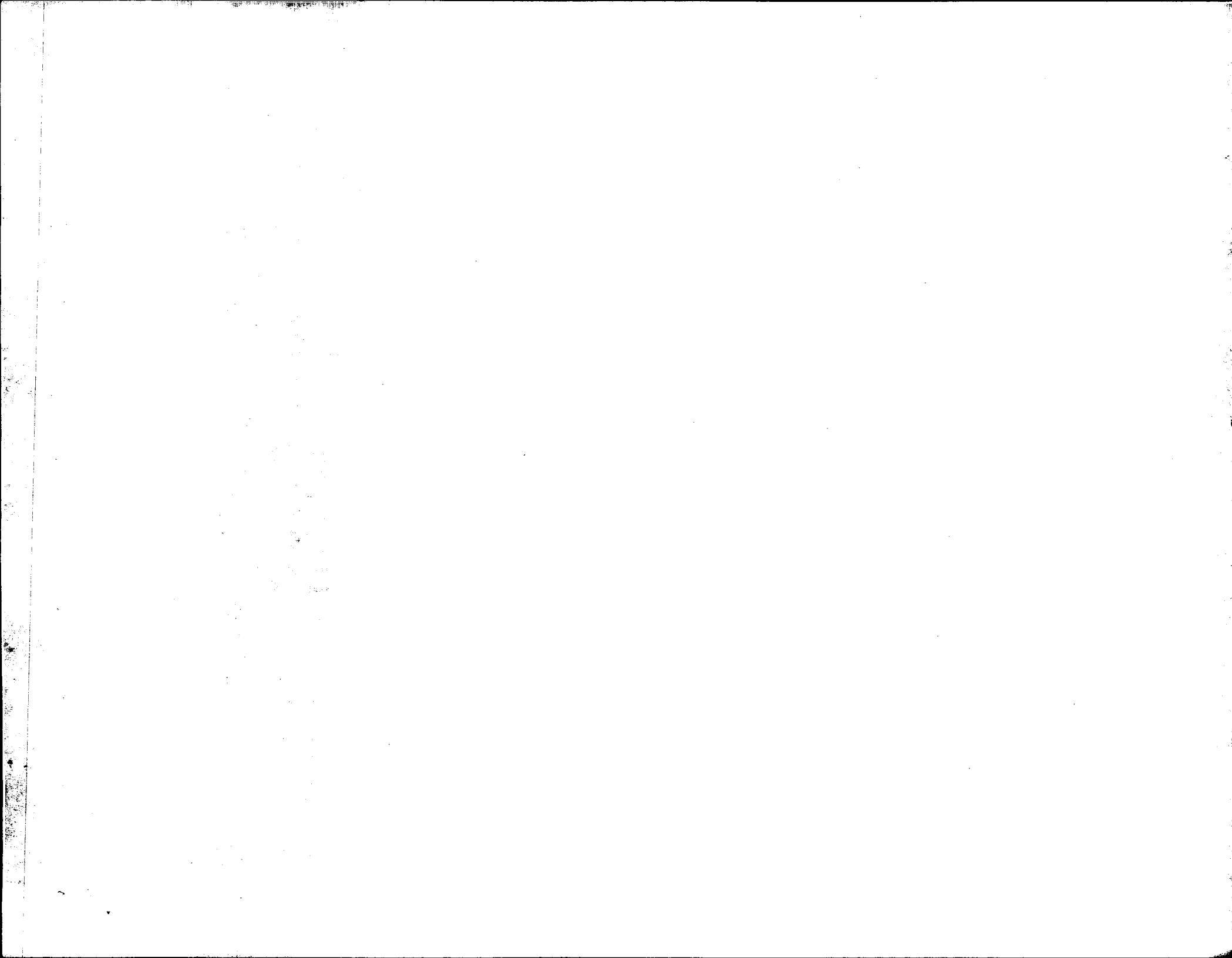
Memo

0.00

Quality Control

12/11/22

MF
12-11-21



Picklist Print

Friday, November 16, 2012 7:30:52 AM

Page 1

Work Order ID: 93501

Parent Item: D3646-2

Parent Item Name: Arm

Start Date: 11/16/2012

Required Date: 11/27/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP revA 11.07.12 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			100	f	371.9762	2.11	8.8842105			
304 RD Tube .500 x .035W													

SAD 12-11-12

Location

Loc Qty

Loc Code

MAT017

371.9762123

115535

0.913

116720

1.66068

117598

7.6415923

119160

4.79

120633

70.1979

121848

93.30774

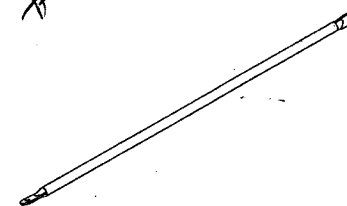
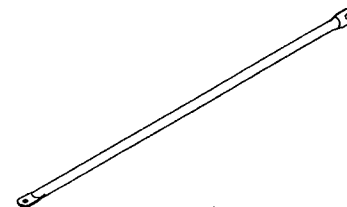
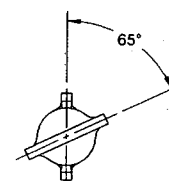
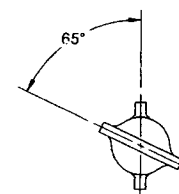
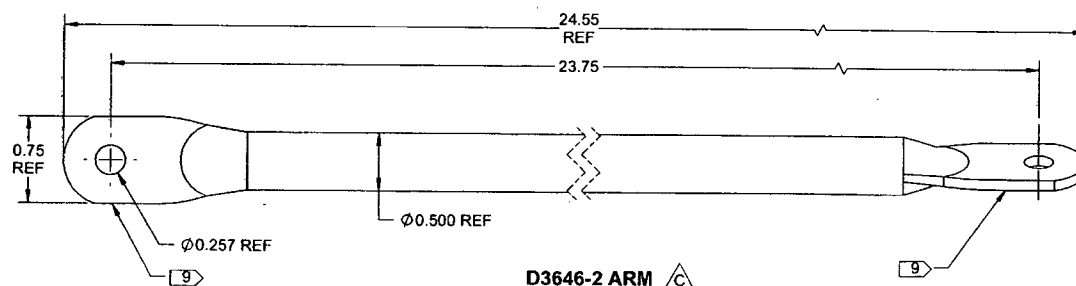
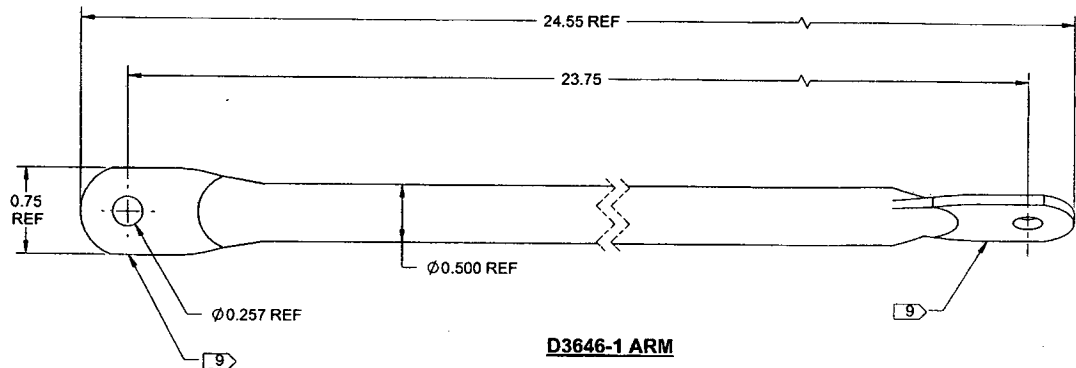
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125.9553

123449

67.51

8.8843

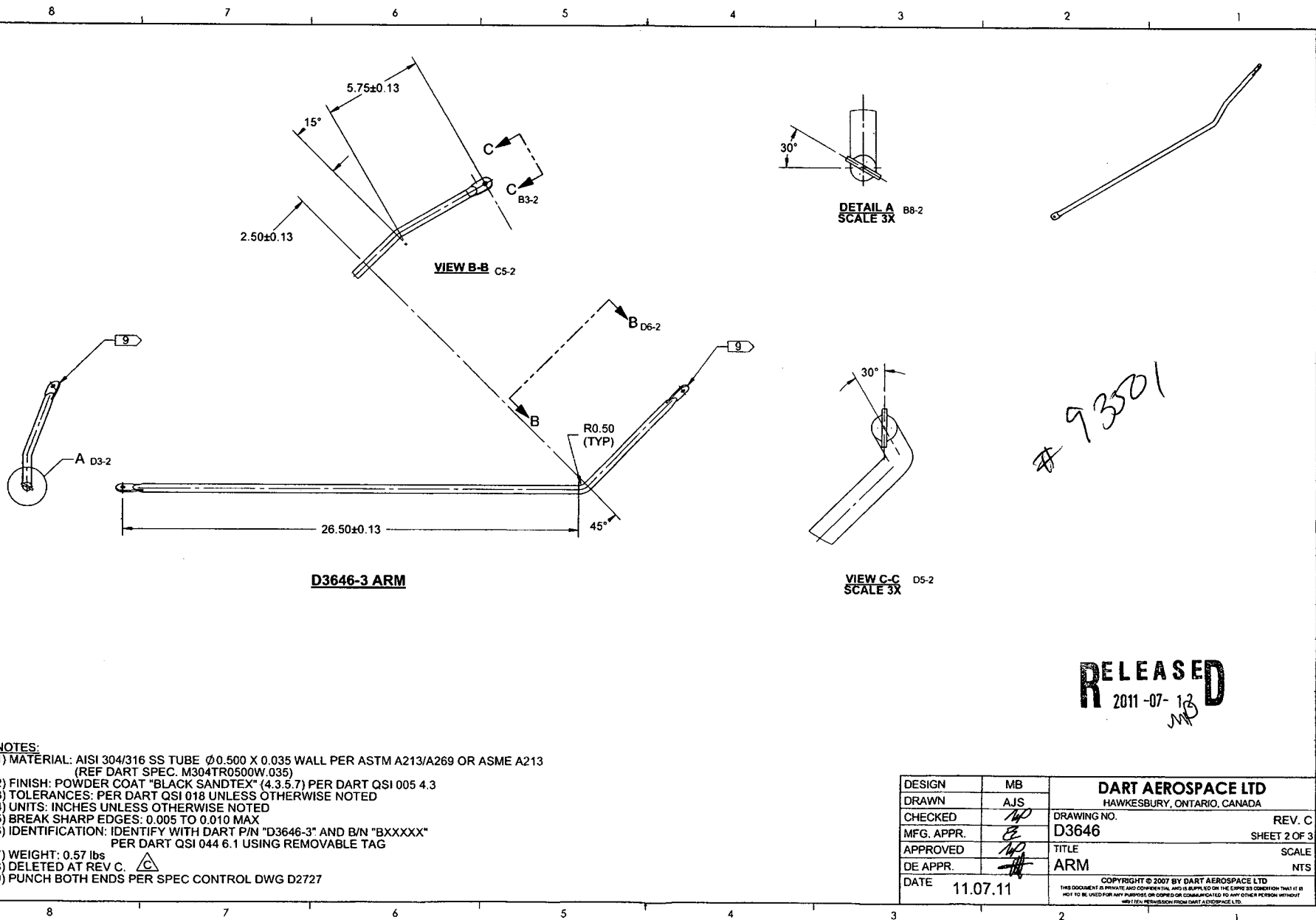


RELEASED
2011-07-13

NOTES:

- 1) MATERIAL: AISI 304/316 SS TUBE $\phi 0.500 \times 0.035$ WALL PER ASTM A213/A269 OR ASME A213 (REF DART SPEC. M304TR0500W.035)
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3646-X" AND B/N "BXXXXX" PER DART QSI 044 6.1 USING REMOVABLE TAG
- 7) WEIGHT: 0.38 lbs
- 8) DELETED AT REV. C
- 9) PUNCH BOTH ENDS PER SPEC CONTROL DWG D2727

C	ADD-2 & -4 FOR LHS INSTALLATION. DELETE REFERENCES TO TEMPLATES (NOTE 8) PER SHOP REQUEST.	AJS	11.07.11
B	REFORMAT DWG, ANGLE 65° WAS 45° (ZN C3-1), ADD IDENTIFICATION TAG (ZN AB-1, AB-2)	CP	09.06.04
A	NEW ISSUE	MB	07.06.06
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	MB	DRAWING NO.	REV. C
MFG. APPR.	MB	D3646	SHEET 1 OF 3
APPROVED	MB	TITLE	SCALE
DE APPR.	MB	ARM	NTS
DATE	11.07.11	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3646-3" AND B/N "BXXXXX" PER DART QSI 044 6.1 USING REMOVABLE TAG
- 7) WEIGHT: 0.57 lbs
- 8) DELETED AT REV C.
- 9) PUNCH BOTH ENDS PER SPEC CONTROL DWG D2727

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3646	REV. C SHEET 2 OF 3
MFG. APPR.		TITLE ARM	SCALE NTS
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DE APPR.			
DATE	11.07.11		

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2011-07-13

8 7 6 5 4 3 2 1

D

C

B

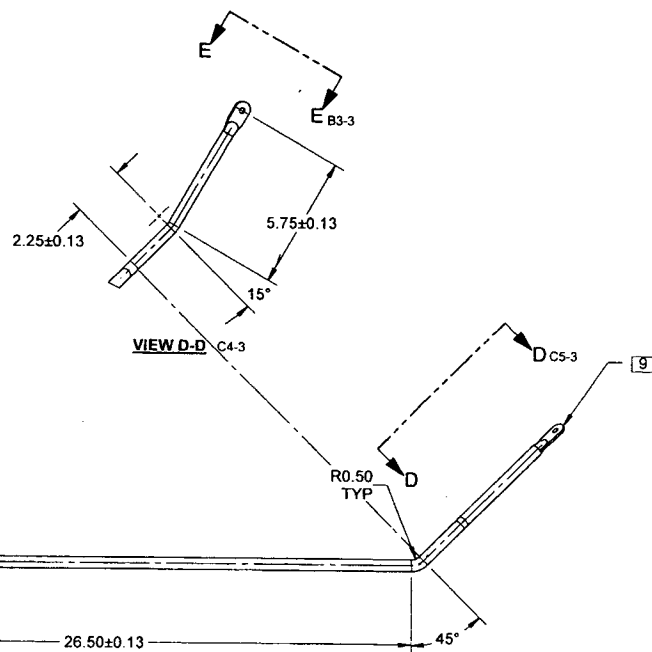
A

D

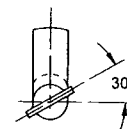
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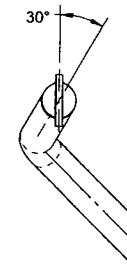
A



D3646-4 ARM



VIEW F B8-3



VIEW E-E D5-3

#93501

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2011-07-13
JMP

NOTES:

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- 2) FINISH: POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3646-4" AND B/N "BXXXXX" PER DART QSI 044 6.1 USING REMOVABLE TAG
- 7) WEIGHT: 0.57 lbs
- 8) DELETED AT REV C.
- 9) PUNCH BOTH ENDS PER SPEC CONTROL DWG D2727

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3646	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ARM	NTS
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8 7 6 5 4 3 2 1

